

Date: Monday, 8/21/2006 2:37:33 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28289
 Estimate Number : 12482
 P.O. Number : N/A
 This Issue : 8/21/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : PURCHASED PARTS
 Previous Run : 27814
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 06-07-03 JLM

Drawing-Name : SADDLE BILLET (6061)
 Part Number : D6102013
 Drawing Number : D6102 PRELIMINARY D (8.06.2)
 Project Number : N/A
 Drawing Revision : PREL D
 Material : N/A
 Due Date : 8/28/2006 Qty: 80 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0 PG

PURCHASING



Comment: Issue P/O: 1895

- a) Description: Aluminum Billet
 b) 7.000" x 6.500" x 2.000" thick
 c) Tolerance on all dimensions is +0.06/0.00
 d) Grain direction along 6.500" length
 e) Material: 6061-T6/T6511 (QQ-A-250/11 or QQ-A-200/8)
 Material release certificate is required

C Ld6/08/23

(80)

2.0

D6102013P

6061-T6 7.0x6.5x2.0



Comment: Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s)
 6061-T6 6.0x11.0x5.0

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure material certification is attached

A 6/9/01

(80)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Check certification to Dwg D6102 for compliance

J.G

06/09/20

80

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: /

A 6/9/01

80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 06/09/21

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 8/21/2006 2:37:34 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET (6061)

Job Number: 28289

Part Number: D6102013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

DP 06/09/21

Job Completion



Cu 06-09-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

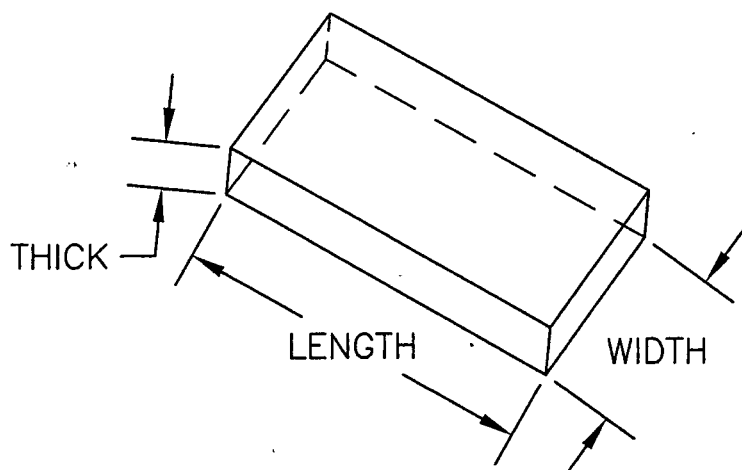
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN #	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D6102	Rev. D SHEET 1 OF 1
DATE 06.06.30		TITLE SADDLE BILLET, 6061	SCALE NTS
A	01.03.30	NEW ISSUE	
B	03.10.20	ADD D6102-005/-007/-009	
C	04.08.25	ADD D6102-010/-011	
D	06.06.30	ADD D6102-013	

SPECIFICATION CONTROL DRAWING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28289

RELEASED

06.08.15 #

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.06/-0.00), AND GRAIN DIRECTION AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.06/-0.00.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6102-001	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.880	6.250	2.000	Along 7.880 Length
D6102-003	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.000	6.250	2.000	Along 6.000 Length
D6102-005	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	47.85	15.250	1.000	Along 47.85 Length
D6102-007	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.500	7.000	2.500	Along 7.500 Length
D6102-009	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	11.000	6.000	5.000	Along 11.000 Length
D6102-010	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.950	8.250	2.500	Along 7.950 Length
D6102-011	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	8.250	2.500	Along 6.500 Length
D6102-013	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	7.000	2.000	Along 6.500 Length

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

COPPER AND BRASS SALES

MATERIAL TYPE ALUMINUM ALLOYS

PRODUCT DESIGNATION

1100 1350 3003 3004 3105 5005 5083 5086 5182 5454 6061 6063

"WARNING"

SMALL CHIPS, FINE TURNINGS AND DUST MAY IGNITE READILY. EXPLOSION POTENTIAL MAY BE PRESENT WHEN: DUST OR FINES ARE DISPERSED IN THE AIR; FINE, DUST OR MOLTEN ALUMINUM ARE IN CONTACT WITH CERTAIN METAL OXIDES; OR, CHIPS, FINES, DUST OR MOLTEN ALUMINUM ARE IN CONTACT WITH WATER OR MOISTURE. KEEP AWAY FROM IGNITION SOURCE. USE EXPLOSION-PROOF VENTILATION. KEEP MATERIAL DRY.

INHALING LARGE AMOUNTS OF COPPER, MAGNESIUM OXIDE, MANGANESE OXIDE, AND ZINC OXIDE FUMES OR DUST MAY CAUSE METAL FUME FEVER WITH FLU-LIKE SYMPTOMS. CHRONIC OVEREXPOSURE TO COPPER MAY CAUSE THICKENING OF THE SKIN; AND SKIN, TEETH, AND HAIR DISCOLORATION. CHRONIC OVEREXPOSURE TO MANGANESE DUST CAN CAUSE CENTRAL NERVOUS SYSTEM DAMAGE, SCARRING OF THE LUNGS AND REPRODUCTIVE HARM IN MALES. TARGET ORGAN IS PRIMARILY THE LUNG, BUT REPEATED HIGH EXPOSURE CAN ALSO AFFECT THE LIVER. CHRONIC OVEREXPOSURE TO TIN DUST OR IRON OXIDE DUST/FUME MAY CAUSE LUNG SIDEROSIS. CHRONIC OVEREXPOSURE TO SILICON DUST CAN CAUSE CHRONIC BRONCHITIS.

THIS PRODUCT ALSO CONTAINS LEAD AND CHROMIUM COMPOUNDS. LEAD IS KNOWN TO CAUSE REPRODUCTIVE TOXICITY AND IS A KNOWN CARCINOGEN. EXPOSURE TO CHROMIUM DUST OR FUME MAY CAUSE METAL FUME FEVER WITH FLU-LIKE SYMPTOMS AND KIDNEY AND LIVER DAMAGE. UNDER HIGH TEMPERATURES, HEXAVALENT CHROMIUM MAY BE PRODUCED, IF IN THE INSOLUBLE FORM, IT IS A CONFIRMED HUMAN CARCINOGEN. (CALIFORNIA PROPOSITION 65)

IF COATED WITH OIL, MAY CAUSE SKIN IRRITATION/DERMATITIS BY CONTACT. WELDING FUME IS LISTED AS A POSSIBLE CARCINOGENIC TO HUMANS.

READ THE ALUMINUM/ALUMINUM ALLOYS MATERIAL SAFETY DATA SHEET(MSDS) ON-FILE WITH YOUR EMPLOYER BEFORE WORKING WITH THIS MATERIAL

- * If processing or recycling produces particulate, use exhaust ventilation or other controls designed to prevent exposure to workers. Examples of such activities include melting, welding, grinding, abrasive sawing, sanding and polishing. Any activity which abrades the surface of this material can generate airborne particulate. Use respiratory protection (P100, quantitative fit testing required) if exposures exceed the permissible limits.
- * The Occupational Safety and Health Administration (OSHA) have set mandatory limits on occupational exposures.
- * Aluminum, in solid form and as contained in finished products presents no special health risk.
- * Sold for manufacturing purposes only. This product can be recycled; contact your sales representative.

The Occupational Safety and Health Administration require employers to provide training in the proper use of this product

For additional information, call or write to Copper and Brass Sales, 22355 West Eleven Mile Road, Southfield, MI 48033, telephone 248-233-5600, or visit our web site @ www.copperandbrass.com.

Alcan Aluminium Valais SA

CH-3960 Sierre
Suisse

ALCAN ROLLED PRODUCTS

Tel : +41(0) 27 457 51 11
www.alcan.com



PECHINEY WORLD TRADE USA

333 LUDLOW STREET
US -06902 STAMFORD

INSPECTION CERTIFICATE

According To **EN 10204-3.1**
Disp. Advice / Cert **0080142397**
Date **20/06/2006** Page **1**

Your Order **Copper and Brass Sal**
PO CJ5990

Project

Dated **05/03/2006**
Our Confirmation-No. **91800-10**
Customer No. **604861**
Sales Contact **Gérald Gaspoz**
027 457 59 43
Certificate Dpt : **41 27 457 68 15/6**

Aluminium Plate AA6061-T651, mill finish, slightly oiled,
To AMS QQ-A-250/11, ASTM B209-02a, ASME SB209-04 and SIE0001-02
Alumitex paper interleaved

Your article **PO CJ5990 / 6061-T651**

Lot	Production No.	Weight	Quantity	Dimensions
J12144	6154401	3478.84 Lbs	2	2.000" x 60.50" x 144.50"

Mechanical and technological properties

Sample	Tempe	Psi-UTS	Psi-YS	A%2Inch	HB							
min-max	T651	>=42000	>=35000	>=8								
min-max												

Measured values

1	T651	48500	42300	13	101							
2	T651	48500	42400	15	101							

Chemical composition

Required composition (% by weight)

Casting No	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti		
Min	.40		.15		.8	.04					
Max	.8	.7	.40	.15	1.2	.35	.05	.25	.15		

Analysis results (% by weight)

61421311	0.66	0.39	0.23	0.035	0.96	0.21	0.004	0.004	0.014		
----------	------	------	------	-------	------	------	-------	-------	-------	--	--

Remark

Use of abbreviations on demand

A. Eden
Inspection Department
Valid without signature 01



Part #
090085
W cut bar
into billets
to size
req'd

